

Work Order ID 113759

\*113759\*

Page 1

February-24-14 10:03:02 AM

Item ID: D3589-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Latch Assembly

Stop

\*NS2\*

Start Date: 2/27/14

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 2/27/14

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-02-26

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3589	C	

100

0.00

\*100\*

Large Fab

Memo 0.00

Large Fab

1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

\*\*\* ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS\*\*\*

4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004  
\*\*\*ensure parts fit correctly on jig\*\*\*

A/R Stainless Steel Rod Batch: M125054

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

(4) 14-04-16

DAS  
9  
9.59

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>					
				Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				<b>General</b> Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence		Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	

Work Order ID 113759

\*113759\*

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February-24-14 10:03:02 AM

Item ID:	D3589-041	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Latch Assembly						
Start Date:	2/27/14	Start Qty:	4.00	*4*	Cust Item ID:		
Required Date:	2/27/14	Req'd Qty:	4.00	*4*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00				④ 1404-16	0		DAS 9.00
130 <b>*130*</b> Small Fab	Memo	0.00				4			FF 14-04-22
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00	DAS 27 9.00	4					

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General							
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>			
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>			
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>				
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>					
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>					
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					

**Work Order ID 113759**

**\*113759\***

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Item ID:	D3589-041	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>	
Revision ID:						Stop	<b>*NS2*</b>
Item Name:	Latch Assembly						
Start Date:	2/27/14	Start Qty:	4.00	<b>*4*</b>	Cust Item ID:		
Required Date:	2/27/14	Req'd Qty:	4.00	<b>*4*</b>	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop		<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location:	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
26  
9-89

PPP 2x B 113819  
2x B 1091583

MLJ 14-4-23

MLJ 14-04-23

MLJ 14-04-23

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: \_\_\_\_\_

Part No. \_\_\_\_\_

NCR No. \_\_\_\_\_

**DISPOSITION**

- Rework
- Scrap
- Use-as-is
- Suspected Unapproved

**AGAINST DEPARTMENT/PROCESS**

- |  |                                    |  |                                      |
|--|------------------------------------|--|--------------------------------------|
| <input type="checkbox"/> Skid-tube     | <input type="checkbox"/> Crosstube | <input type="checkbox"/> Water Jet           | <input type="checkbox"/> Engineering |
| <input type="checkbox"/> Machining     | <input type="checkbox"/> Small Fab | <input type="checkbox"/> Prod. Eng. Coor.    | <input type="checkbox"/> Quality     |
| <input type="checkbox"/> Thermoforming | <input type="checkbox"/> Finishing | <input type="checkbox"/> Rec/Store/Packaging | <input type="checkbox"/> Other       |
| <input type="checkbox"/> Large Fab     | <input type="checkbox"/> Composite | <input type="checkbox"/> Supplier            | <input type="checkbox"/>             |

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General				
Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	
Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	
Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	
Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	
Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	
Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong		
Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other	
Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread			
Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set			
Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration			
Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence			

# Picklist Print

Page 1

February-24-14 10:03:01 AM

Work Order ID: 113759

**\*113759\***

Parent Item: D3589-041

**\*D3589-041\***

Parent Item Name: Latch Assembly

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

**Comments:** IPP Rev:A new issue .08-06-05 DD verified by:ec IPP RevB: revise process as per coss DD 10.01.18 verified by:EC IPP REV:C 12.07.23 AS PER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3589-1		Manufactured	No			100	Each	6.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D3589-1\***

Arm

Location	Loc Qty	Loc Code
WA002 113215	6	
104631	6	

D3589-11		Manufactured	No			100	Each	4.0000	1	4			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D3589-11\***

Fwd Guide Plate

Location	Loc Qty	Loc Code
WA002 113568	4	
77695	4	

D3589-13		Manufactured	No			100	Each	5.0000	2	8			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D3589-13\***

Lug

Location	Loc Qty	Loc Code
WA002 113170	5	
104589	5	

D3589-15		Manufactured	No			130	Each	6.0000	2	8			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D3589-15\***

Link

Location	Loc Qty	Loc Code
WA002 113162	6	
104737	6	

3

14-03-26

JBL

14-03-26

PL

14-03-26

PL

FF 14-04-22

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General								
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

**Picklist Print**

Page 2

February-24-14 10:03:02 AM

Work Order ID: 113759

**\*113759\***  
**\*D3589-041\***

Parent Item: D3589-041

Parent Item Name: Latch Assembly

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

D3589-23

Manufactured No

100

Each

23.0000

2

8

**\*\*****\*D3589-23\***

Arm Guide

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	23	
104477	3	
[ 105462 ]	20	

D3589-3

Manufactured No

130

Each

39.0000

2

**\*\*****\*D3589-3\***

Arm Guide

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	39	
105461	19	
110528	20	

D3589-7

Manufactured No

100

Each

0.0000

1

4

**\*\*****\*D3589-7\***

Aft Guide Plate

D3589-9

Manufactured No

100

Each

2.0000

1

4

**\*\*****\*D3589-9\***

Fwd Guide Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002 113089	2	
96364	2	

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: \_\_\_\_\_

Part No. \_\_\_\_\_

NCR No. \_\_\_\_\_

**DISPOSITION**

- Rework  
Scrap  
Use-as-is  
Suspected Unapproved

**AGAINST DEPARTMENT/PROCESS**

- |               |           |                     |             |
|---------------|-----------|---------------------|-------------|
| Skid-tube     | Crosstube | Water Jet           | Engineering |
| Machining     | Small Fab | Prod. Eng. Coor.    | Quality     |
| Thermoforming | Finishing | Rec/Store/Packaging | Other       |
| Large Fab     | Composite | Supplier            |             |

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General				
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced	
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up	
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure	
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld	
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled	
Crushing	Countersink	Misaligned/off center	Positioned Wrong		
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other	
Inspection Strip in Tube	Drawing	Misread			
Marks/Chatter	Drill Holes	Off-set			
Turning Sequence	Finish	Out of Calibration			
Wave/Twist in Tube	Fit/Function	Out of Sequence			

**Picklist Print**

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February-24-14 10:03:02 AM

Work Order ID: 113759

**\*113759\***

Parent Item: D3589-041

**\*D3589-041\***

Parent Item Name: Latch Assembly

Start Date: 2/27/14

Required Date: 2/27/14

MS20392-1C7

Purchased

No

130

Each

38.0000

2

8

**\*\***

FF

14-04-22

**\*MS20392-1C7\***

Pin

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST333	38	
123348	4	
125646	2	
m125807	20	
<u>m127304</u>	12	

MS24665-1010

Purchased

No

130

Each

262.0000

2

8

**\*\***

FF

14-04-22

**\*MS24665-1010\***

COTTER PIN

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST323	262	
108335	200	
<u>114405</u>	62	

NAS1149DN432J

Purchased

No

130

Each

194.0000

4

16

**\*\***

FF

14-04-22

**\*NAS1149DN432J\***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST293	94	
<u>m127306</u>	94	
st510	100	
m127832	100	

DOA:

Date:

## **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed:

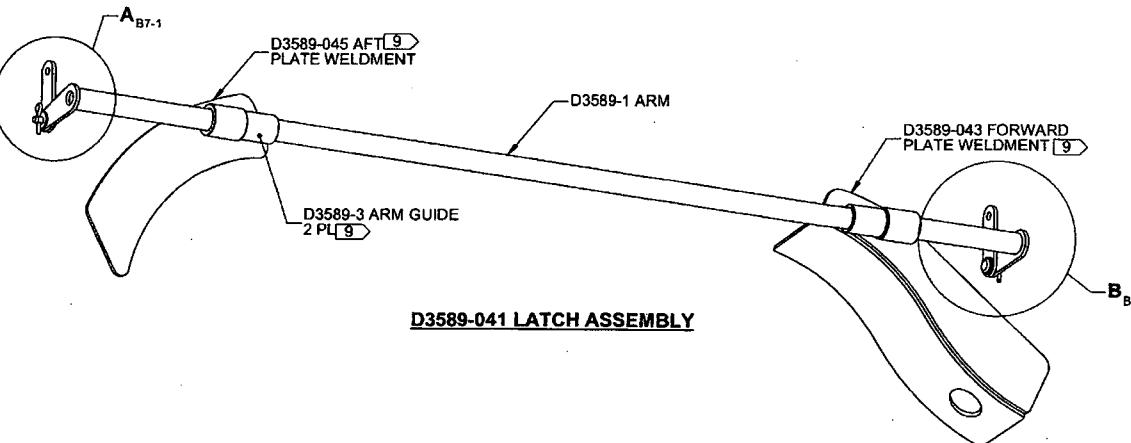
Date:

## Work Order update only



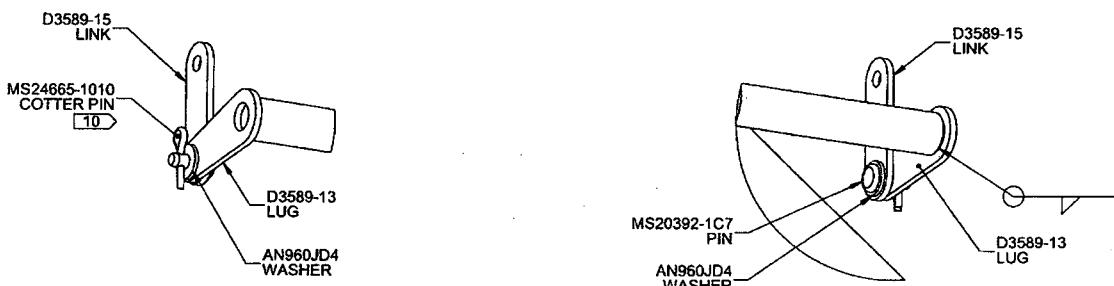
Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced			
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up			
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure			
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld			
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
Crushing		Countersink		Misaligned/off center		Positioned Wrong					
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge					
Inspection Strip in Tube		Drawing		Misread							
Marks/Chatter		Drill Holes		Off-set							
Turning Sequence		Finish		Out of Calibration							
Wave/Twist in Tube		Fit/Function		Out of Sequence							

ITEM	QTY. -041	P/N.	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY	
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN



113759 MWJ  
14-02-26

RELEASED  
2012-07-16  
M



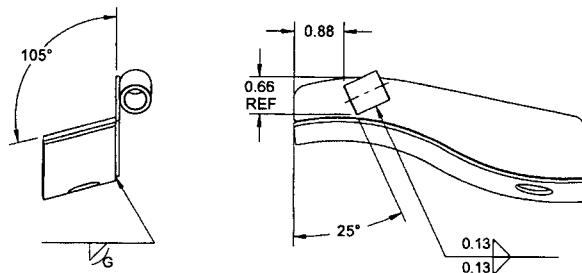
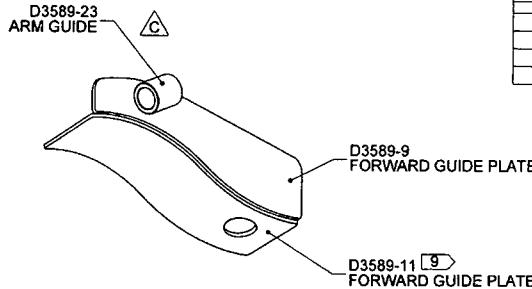
**DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL** C3-1

SCALE 2X  
2 PL

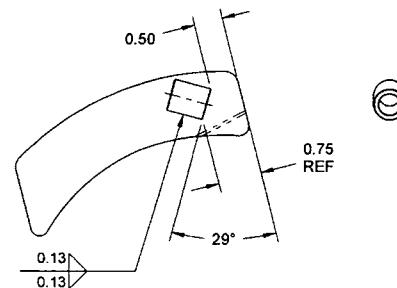
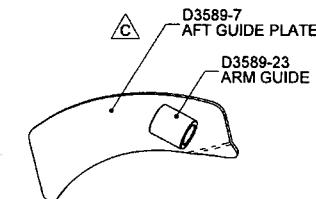
C	REVISED D3589-5. 2.75 WAS 3.00 (ZN B6-4); ADDED D3589-21 (ZN B3-4). AFFECTS D3885-047 (ZN A7-3) AND D3885-048 (ZN A7-3). ADDED D3589-15. 0.140 WAS 0.120 (ZN B4-7). 0.90 WAS 1.15 (ZN B4-7). ADDED D3589-23 (ZN C3-4). AFFECTS D3589-043-045 (ZN D7-2 AND D2-2). REASON: PAR12-177.	MB	12.07.04
B	0.00 AND 0.63 REF WERE 1.07 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 18.00 WAS 18.88 (ZN D4-2); 29° WAS 15° (ZN B2-2); 18.00 WAS 18.88 (ZN D4-2). REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3). REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
	X		D3589-043	FORWARD PLATE WELDMENT
	X		D3589-045	AFT PLATE WELDMENT
1	1		D3589-7	AFT GUIDE PLATE
2	1		D3589-9	FORWARD GUIDE PLATE
3	1		D3589-11	FORWARD GUIDE PLATE
4	1	1	D3589-23	ARM GUIDE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

RELEASED  
2012-07-16  
1W

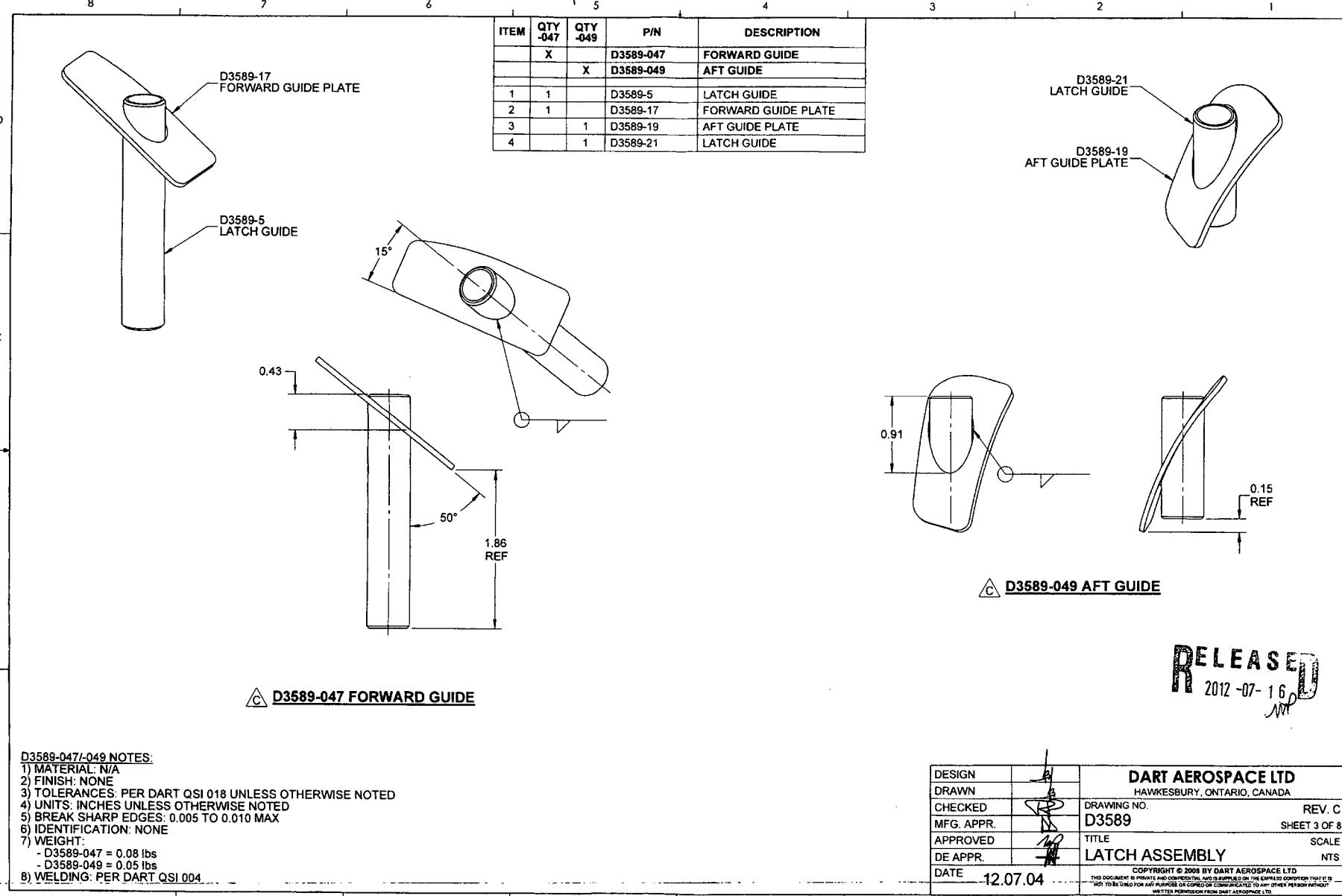
D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
  - D3589-043 = 0.23 lbs
  - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>1</i>	REV. C	
APPROVED	<i>10</i>	SHEET 2 OF 8	
DE APPR.	<i>11</i>	TITLE	LATCH ASSEMBLY
DATE	12.07.04	SCALE	NTS

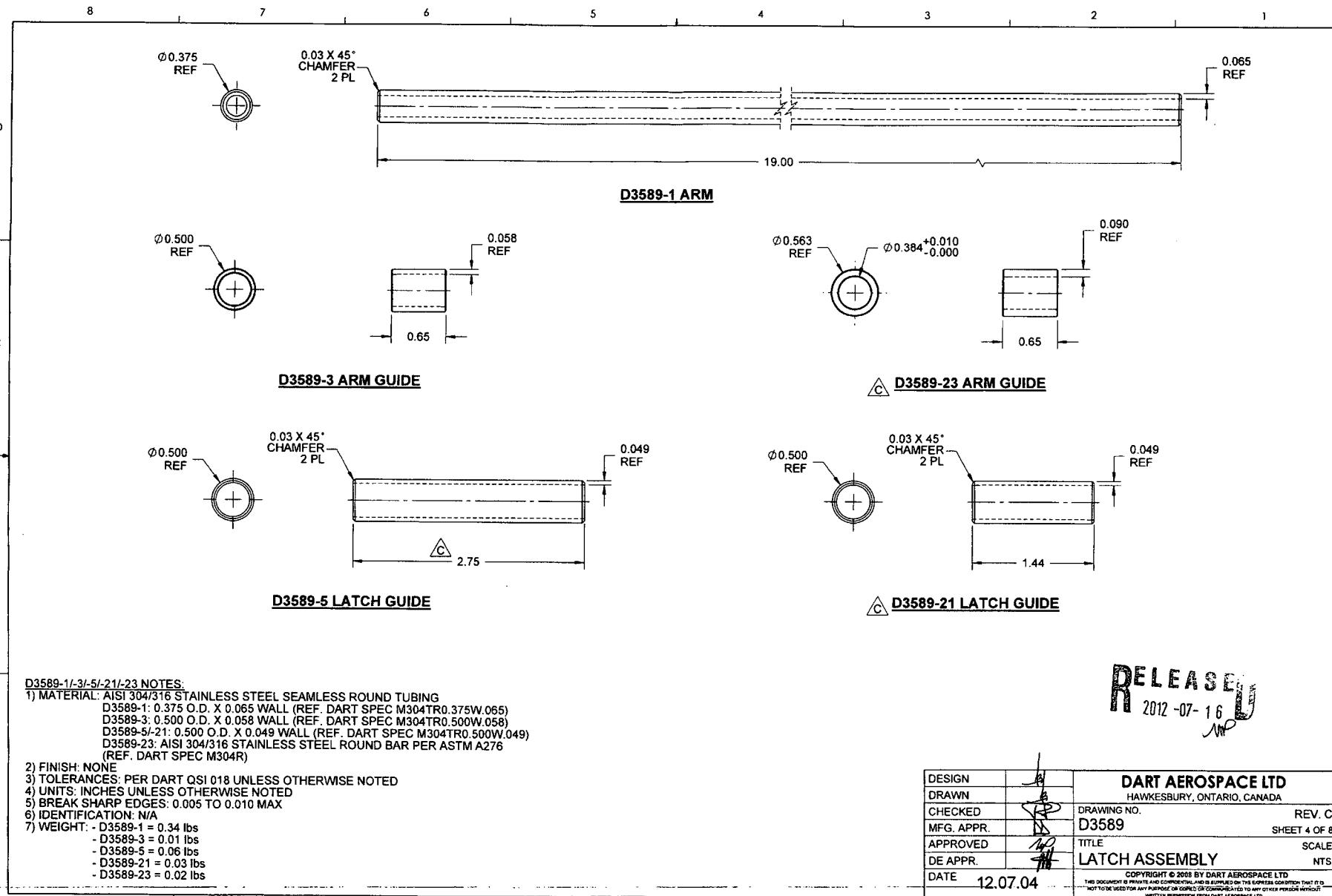
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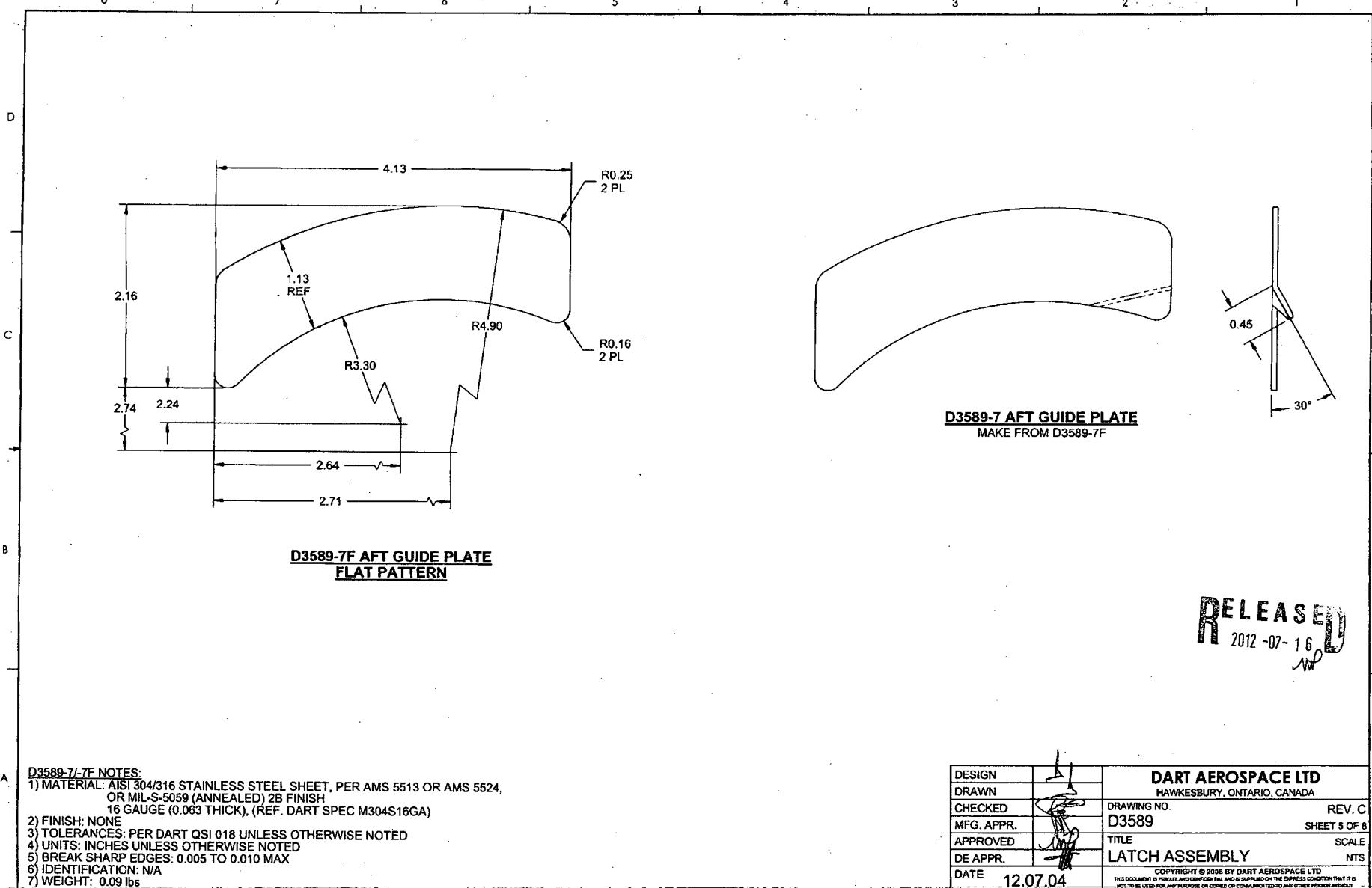


DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>T</i>	DRAWING NO.	
MFG. APPR.	<i>N</i>	REV. C	
APPROVED	<i>10</i>	SHEET 3 OF 8	
DE APPR.	<i>10</i>	TITLE	
DATE 12.07.04		SCALE	
		NTS	
LATCH ASSEMBLY			

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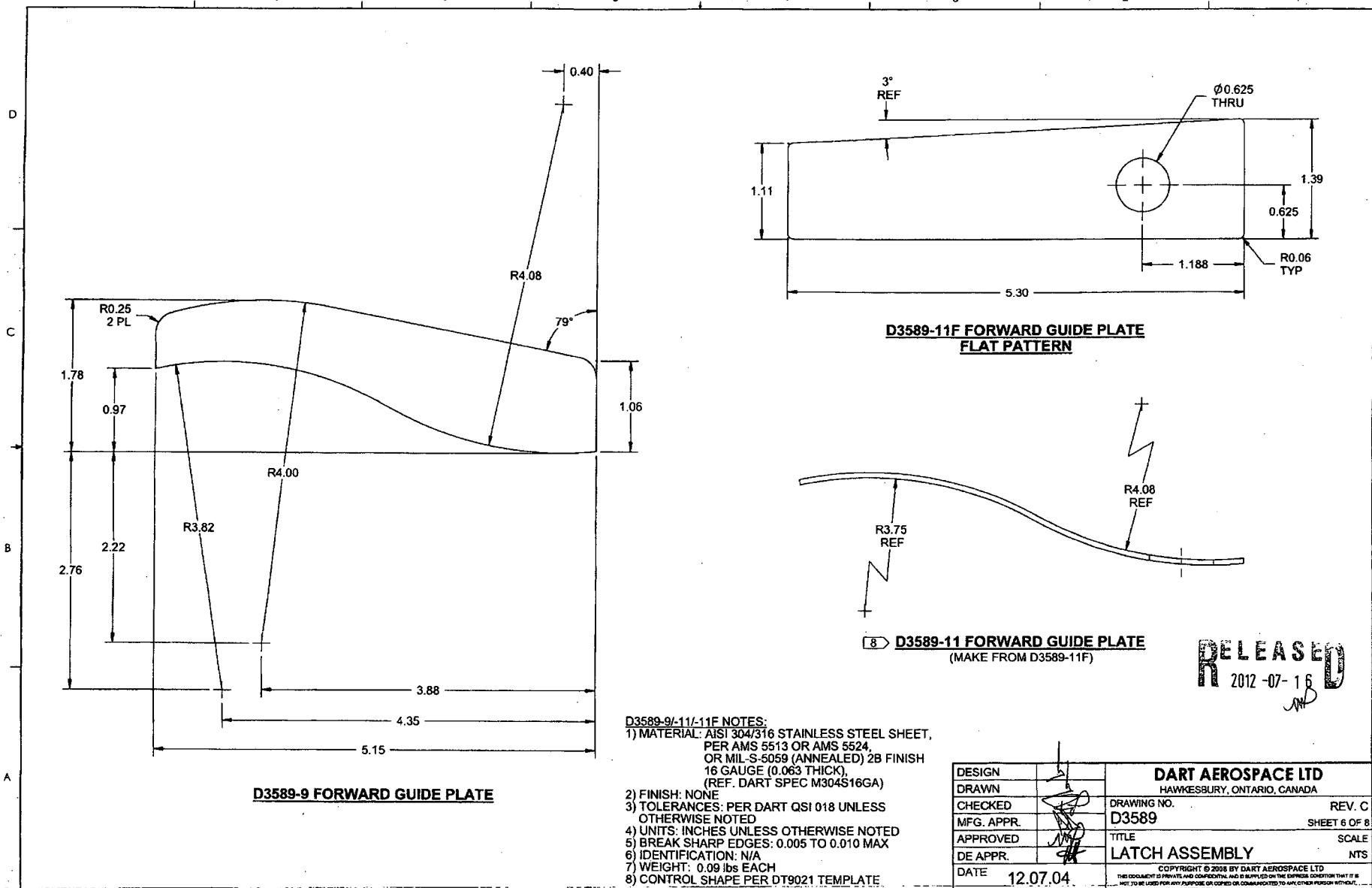


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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY	NTS
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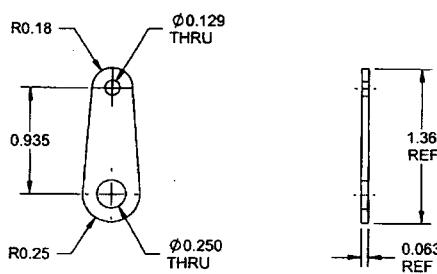


8 D3589-11 FORWARD GUIDE PLATE  
(MAKE FROM D3589-11F)

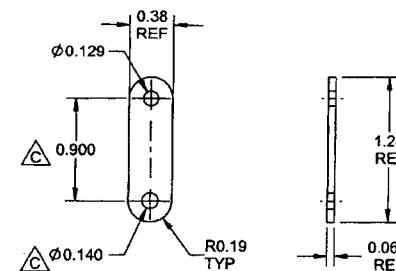
RELEASED  
2012-07-16  
*[Signature]*

- D3589-9/-11/-11F NOTES:**
- MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK) (REF. DART SPEC M304S16GA)
  - FINISH: NONE
  - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - UNITS: INCHES UNLESS OTHERWISE NOTED
  - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - IDENTIFICATION: N/A
  - WEIGHT: 0.09 lbs EACH
  - CONTROL SHAPE PER DT9021 TEMPLATE

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY	NTS
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D3589-13 LUG



D3589-15 LINK

RELEASED  
2012-07-16  
MWD

A D3589-13/15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK). (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. C
APPROVED	<i>[Signature]</i>	D3589
DE APPR.	<i>[Signature]</i>	SHEET 7 OF 8
DATE	12.07.04	TITLE
		SCALE
		NTS
		LATCH ASSEMBLY

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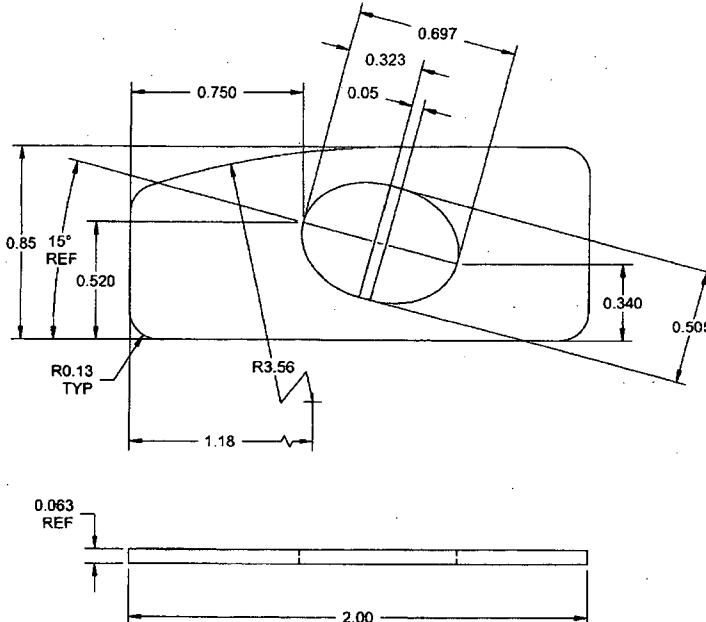
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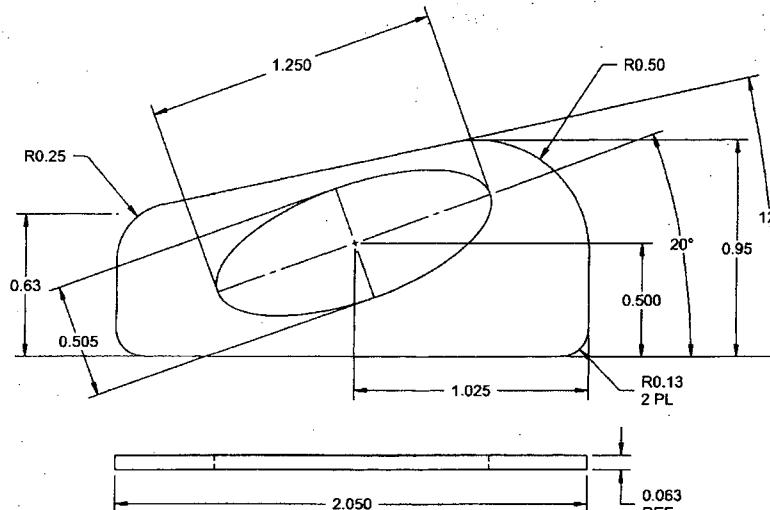
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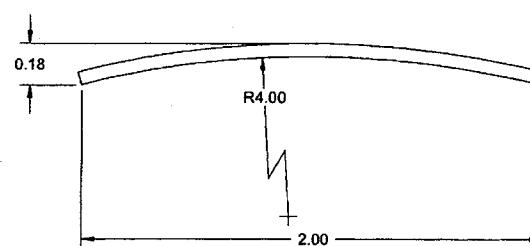
A



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN

D3589-19 AFT GUIDE PLATE  
(MAKE FROM D3589-19F)

**RELEASED**  
R 2012-07-16  
*[Handwritten signature]*

**D3589-17/19-19F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

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CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. C
APPROVED	<i>[Signature]</i>	D3589
DE APPR.	<i>[Signature]</i>	SHEET 8 OF 8
DATE	12.07.04	TITLE
		LATCH ASSEMBLY
		SCALE
		NTS

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